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D3255-042
Job Sheet 206819



Part No: D3255-042

Job Qty: 2 pcs

Part Name: Access Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/12/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 3/6/20

Description:

Type: Stock

Note: DWG REV B IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	2 pcs	3/6/20		0.00	6.06	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		MK Feb 26/20
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 10	2 pcs	3/6/20		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
							QC 10 - 68		
120	QC 5	2 pcs	3/6/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		



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Container No: S259222



Part No: D3255-042

Job No: 206819

Serial No/Batch: S259222

Revision:
Location:

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					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	la
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
130	Powdercoat - 3 Grey Sand - B4B	2 pcs	3/6/20	0.00 0.10	Powdercoat - 1 - B4B	BFB20-03-02.
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
140	QC 3	2 pcs	3/6/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	93 80 85 MAR 2 2020
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
150	Small Fab - 2 - B4B	2 pcs	3/6/20	0.29 1.71	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	MAR 03 2020
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					Small Fab - Various 1 - B4B	
160	QC 5	2 pcs	3/6/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	

170	Packaging 3-1 - Stock - B4B	2 pcs	3/6/20	0.00 0.00	QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	MAR 06 2020
					QC 5 - 61	DAS 40
					QC 5 - 81	9-89
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	DAS
					Packaging 3 - 5 - B4B	28
					Packaging 3 - 6 - B4B	9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
180	QC 21 - SA	2 pcs	3/6/20	0.00 0.00	Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS
					Packaging 3 - 37 - B4B	21
						9-89
					QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	
						MAR 10 2020

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: M139028) 1-Weld as per Dwg D3255 ***purge weld***

Descriptions: 110 - (QC10- Inspect visual per QSI004- ground welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: 8:05 TEMP: 320° FINISH: 8:35

5138F39 140 - (QC3- Inspect Part Finish)

150 - (Small Fab) 1-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg D3255

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Identify as per dwg & Stock Location: _____)

180 - QC21- Final Inspection - Work Order Release)

GAW7

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3255-2	Panel	2 pcs (1 ea)	100-Large Fab - Welded Assy-1	5249695
D3255-3	Cap	2 pcs (1 ea)	100-Large Fab - Welded Assy-1	5249735
D3255-5	Gasket	2 pcs (1 ea)	150-Small Fab - 2 - B4B	5247457

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D3255-2	2	2	0
	D3255-3	2	4	0
150-Small Fab - 2 - B4B	D3255-5	2	6	0

Part Specifications

Specifications could not be found.

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube Machining ☐ Large Fab ☐ Cross tube Small Fab ☐ Finishing ☐ Eng. (Non-AW) Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering Water Jet ☐ Supplier ☐ Quality	DEPARTMENT/PROCESS	MRB (QS1042)		
Date : _____		QTY Affected : _____			
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details: _____		FAULT CATEGORY			
		☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up		☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	
		QC / QA Coordinator			